

## Work Order ID 69576

Thursday, May 12, 2011 1:27:07 PM



Page 1

Item ID: D3189-1

Accept



Setup Start



Revision ID:

Item Name: Chafing Shield

Stop



Start Date: 5/12/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11/05/12 Tooling:

Date:

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3189

Rev B

100



Shear

Shear

304.022 11/05/12

Waterjet as pending

0.00

110



Small Fab

Small Fab

Small Fab

0.00

Memo  
Cut to size as per Dwg D3189

0.00

QC 2 → Item 11/05/12

QC 8 → 11/05/16 (21)

0.00

120



QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11/05/19

QC

Quality Control

11/05/16

(21)

11/05/16

(21)

11/05/16

(21)

SB 11/05/17

W/O: 69576

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE <i>*Permanent Change</i>	By	Date	Qty	Approval Chief Eng / Prbd Mgr	Approval QC Inspector
11-06-10		apply a thin <sup>even</sup> layer of Pro seal on inside surface of chafing shield .03"-.06" thick 8T Ref: DSI 9549 REV. A + DEO D412-664-243-E-1	B	11-06-10 11-06-22	21	11-06-10	11-06-13

Part No: D3189-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

**Work Order ID 69576**

Thursday, May 12, 2011 1:27:07 PM



Page 2

Item ID: D3189-1

Accept



Setup

Start



Revision ID:

Item Name: Chafing Shield

Stop



Start Date: 5/12/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

130



Packaging

Identify as per dwg & Stock Location: *X tube**easy*

0.00

*2T 11-06-13 (21)*

Packaging

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/06/13 JJ**CL 11/06/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Thursday, May 12, 2011 1:27:14 PM

Work Order ID: 69576



Parent Item: D3189-1



Parent Item Name: Chafing Shield

Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP B□05.08.22□No longer made in-house□KJ/JLM□  
IPP Rev:C 06-03-24 Rolling Now made in House JLM  
IPP Rev:D 07-04-16 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA 		Purchased		No		100	sf	29.0000	0.32	6.736842 		HB11-5-16	

304/316 .020" Sheet

Location	Loc Qty	Loc Code
MAT20	29	
117285	29	117285

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69576
Description: CHAFING SHIELD	Part Number:	D3189-1
Inspection Dwg: D3189-1, Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

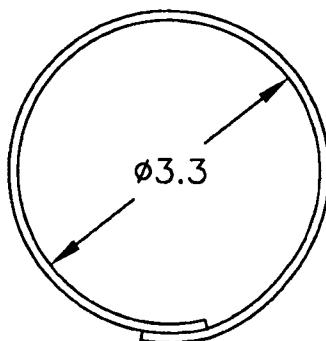
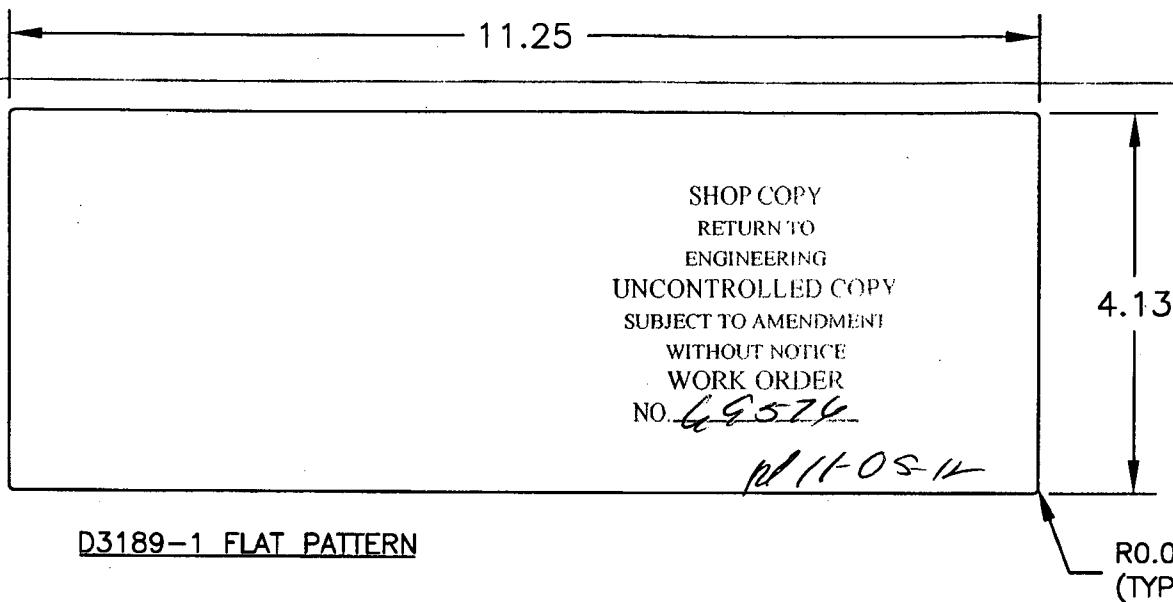
## First Article      Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>11-5-16</u>	Date: <u>W/07/16</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3189 REV. B SHEET 1 OF 2
DATE		TITLE CHAFING SHIELD SCALE 1:2
07.01.05		
A	03.05.08	NEW ISSUE
B	07.01.05	ADD -3

**RELEASED**07.03.27 ~~07.01.05~~

D3189-1 ROLLING DETAIL  
NOT TO SCALE

#### D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

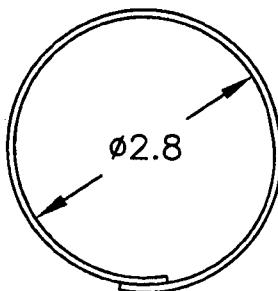
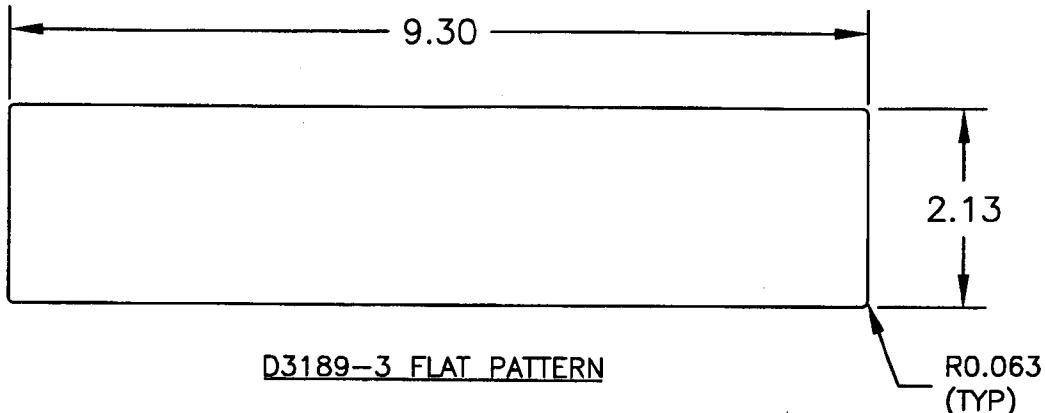
NOTE: Date & initial all entries

**DART**

DESIGN	QP	DRAWN BY	QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>W</del>	APPROVED	<del>W</del>	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE	07.01.05			TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27



D3189-3 ROLLING DETAIL  
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries